

Work Order ID 109571

109571

Page 1

November-28-13 8:51:06 AM

Item ID: D3363-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Console

Start Date: 11/21/13 Start Qty: 6.00

6

Cust Item ID:

Required Date: 11/21/13 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan: W

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3363	Rev C								
100	FLOW WATER JET	0.00							
100									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3363 ***CUT AT 45 DEG GRAIN DIRECTION*****								
6061760063	Dwg Rev: <u>E</u>								
	Prog Rev: <u>E</u>								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.00							
Quality Control									

DAS
27
9/89

13/12/09

6 0 Jm B-12-9

6 0 Jm B-12-9

6

Work Order ID 109571

November-28-13 8:51:06 AM

109571

Page 2

Item ID: D3363-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Console

Start Date: 11/21/13 Start Qty: 6.00

6

Cust Item ID:

Required Date: 11/21/13 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Brake NC Brake NC	Bend as per dwg NC BRAKE Memo Debur Form as per Dwg D3363	0.00 0.00				6			13/12/14
				DAS 30 9-89					
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		SPC 12/11		6			
150 *150* Large Fab Large Fab	Weld per dwg A/R Aluminum rod Batch: <u>m123928</u> Large Fab Memo 1-Weld using DT8790 as per Dwg D3363 and QSI 004 2- Grind weld flush as per dwg	0.00 0.00				(x6)	272	14-01-07	

Work Order ID 109571

109571

Page 3

November-28-13 8:51:06 AM

Item ID: D3363-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Console

Start Date: 11/21/13 Start Qty: 6.00 *6*

Cust Item ID:

Required Date: 11/21/13 Req'd Qty: 6.00 *6*

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
160						(6)	14-01-08		DAS 9 9-89
QC	Memo	0.00							
Quality Control									
170	QC5- Inspect part completeness to step on W/O	0.00							
170						(6)	14-01-08		DAS 9 9-89
QC	Memo	0.00							
Quality Control	I- inspect part with DT8790 jig								
171	Chemical Conversion Coat per QSI005 4.1	0.00							
171									
HandFinish	Memo	0.00							
Hand Finishing									

N/A

DAS
30
9-89

Work Order ID 109571

109571

Page 4

November-28-13 8:51:06 AM

Item ID: D3363-1 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Console
 Start Date: 11/21/13 Start Qty: 6.00 *6* Cust Item ID:
 Required Date: 11/21/13 Req'd Qty: 6.00 *6* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
172	QC3- Inspert Part Finish	0.00							
172									
QC	Memo	0.00							
Quality Control									
180	Identify as per dwg & Stock Location: <u>GA</u>	0.00							
180									
Packaging	Memo	0.00							
Packaging									
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.00							
Quality Control									

DAS
30
9-89

DAS
30
9-89

6

14/02/20

MCS 140220

14-02-20

Picklist Print

November-28-13 8:51:06 AM

Page 1

Work Order ID: 109571

Parent Item: D3363-1

Parent Item Name: Console

Start Date: 11/21/13

Required Date: 11/21/13

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP: B05.09.09Remove c'sink rivet holes and add welding stepKJ/JLM
IPP: C 06.11.15 waterjet EC
IPP Rev:D 08-07-14 add comment in QC5 inspection DD verified by:ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.063 6061-T6 .063 Sheet		Purchased	No			100	sf	775.9565	2.3	(15)		JmB-12-9	

Location

Loc Qty

Loc Code

MAT021

775.9565

123135

120.2625

124003

72.113

M124446

94

M126075

89.242

M127006

151.99

M127420

248.349

123420

DART AEROSPACE LTD		Work Order:	109571
Description: Console		Part Number:	D3363-1
Inspection Dwg: D3363	Rev: C	Page 1 of 2	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.004/-0.001	0.099"	-		✓	Imma
Ø0.128	+0.005/-0.001	0.129"	-		✓	
Ø0.469	+0.006/-0.001	0.469"	-		✓	
14.41	+/-0.030	14.41"	-		T	Imma
14.097	+/-0.010	14.097"	-		T	
12.409	+/-0.010	12.409"	-		T	
11.354	+/-0.010	11.354"	-		✓	
10.706	+/-0.010	10.706"	-		✓	
10.081	+/-0.010	10.081"	-		✓	
4.331	+/-0.010	4.331"	-		✓	
3.706	+/-0.010	3.706"	-		✓	
3.058	+/-0.010	3.058"	-		✓	
2.004	+/-0.010	2.004"	-		✓	
2.366	+/-0.010	2.366"	-		✓	
3.100	+/-0.010	3.100"	-		✓	
5.040	+/-0.010	5.040"	-		✓	
5.415	+/-0.010	5.415"	-		✓	
2.25	+/-0.030	2.25"	-		✓	
19.965	+/-0.010	19.965"	-		T	
20.366	+/-0.010	20.366"	-		T	
21.318	+/-0.010	21.318"	-		T	
22.90	+/-0.030	22.90"	-		T	
0.315	+/-0.010	0.315"	-		✓	
3.706	+/-0.010	3.706"	-		✓	
4.025	+/-0.010	4.025"	-		✓	
7.206	+/-0.010	7.206"	-		✓	
1.75	+/-0.030	1.75"	-		✓	
10.387	+/-0.010	10.387"	-		✓	
19.590	+/-0.010	19.590"	-		T	

DART AEROSPACE LTD		Work Order:	109571
Description: Console		Part Number:	D3363-1
Inspection Dwg: D3363	Rev: C	Page 2 of 2	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
18.990	+/-0.010	18.990"	-		T	
1.80	+/-0.030	1.80"	-		V	
6.390	+/-0.010	6.390"	-		V	
5.790	+/-0.010	5.790"	-		V	
4.475	+/-0.010	4.475"	-		V	
4.100	+/-0.010	4.100"	-		V	
2.725	+/-0.010	2.725"	-		V	
2.00	+/-0.030	2.00"	-		V	
6.363	+/-0.010	6.363"	-		V	
10.737	+/-0.010	10.737"	-		V	
11.206	+/-0.010	11.206"	-		V	
3.206	+/-0.010	3.206"	-		V	
3.675	+/-0.010	3.675"	-		V	

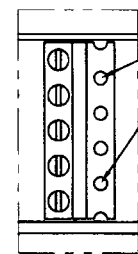
Measured by: Jm	Audited by: DAS 27 g/eg	Prototype Approval:	N/A
Date: 13-12-9	Date: 13/12/09	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.02.28	New Issue	KJ/DD	

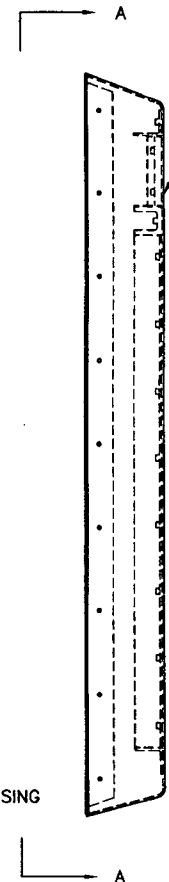


DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
P1	P1		
CHECKED	APPROVED	DRAWING NO.	REV. C
JS	JS	D3363	SHEET 1 OF 3
DATE		TITLE	SCALE
07.01.26		CONSOLE ASSEMBLY	1:5

RELEASED
07.06.04

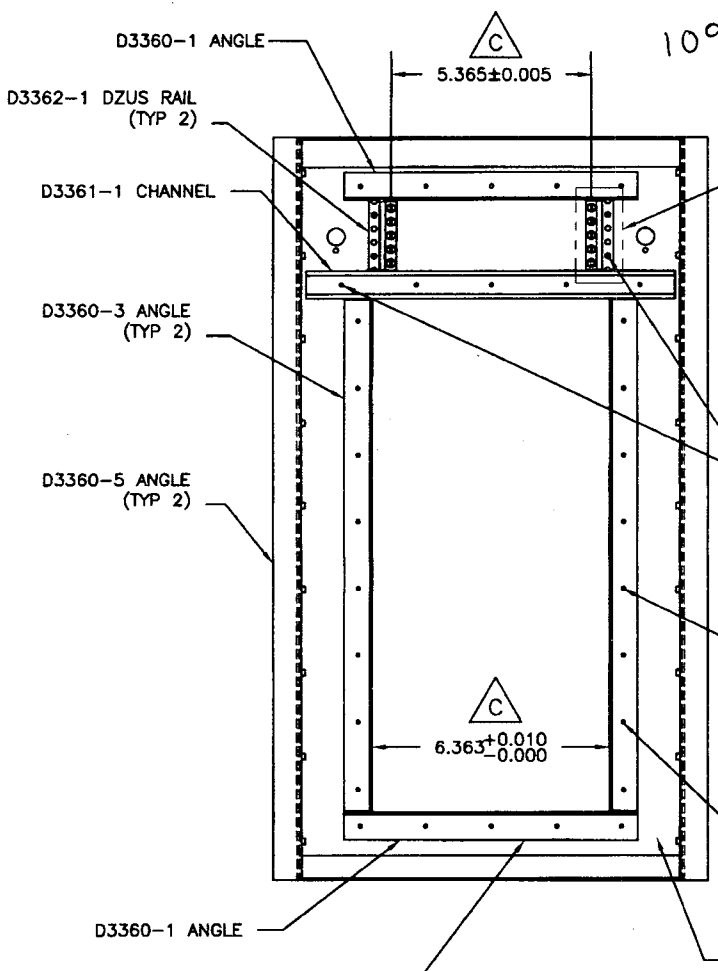


TRANSFER DRILL #30 FROM D3362-1 DZUS RAIL THROUGH D3363-1 CONSOLE (TYP 4 PLACES) C'SINK (#0.225 X 100") FROM TOP SIDE OF CONSOLE



C'SINK THIS SIDE (REF)

109571 MJS
13-11-22



DETAIL C

INSTALL D3361-1 & D3362-1 USING MS20426AD4-6 RIVETS (TYP 9 PLACES)

TRANSFER DRILL #30 FROM MATING PARTS THROUGH #40 HOLES IN D3363-1 CONSOLE (TYP 49 PLACES) C'SINK (#0.225 X 100") FROM CONSOLE TOP SIDE

INSTALL D3360-1/-3/-5 ANGLES USING MS20426AD4-5 RIVETS (TYP 44 PLACES)

D3363-1 CONSOLE

ALIGN EDGES OF ANGLES W/CUTOUT

VIEW A-A FROM UNDER CONSOLE ASSEMBLY

PARTS LIST FOR D3363-041 CONSOLE ASSEMBLY

QTY	PART NUMBER	DESCRIPTION
X	D3363-041	CONSOLE ASSEMBLY
2	D3360-1	ANGLE
2	D3360-3	ANGLE
2	D3360-5	ANGLE
1	D3361-1	CHANNEL
2	D3362-1	RAIL
1	D3363-1	CONSOLE
44	MS20426AD4-5	RIVET
9	MS20426AD4-6	RIVET

D3363-041 CONSOLE ASSEMBLY

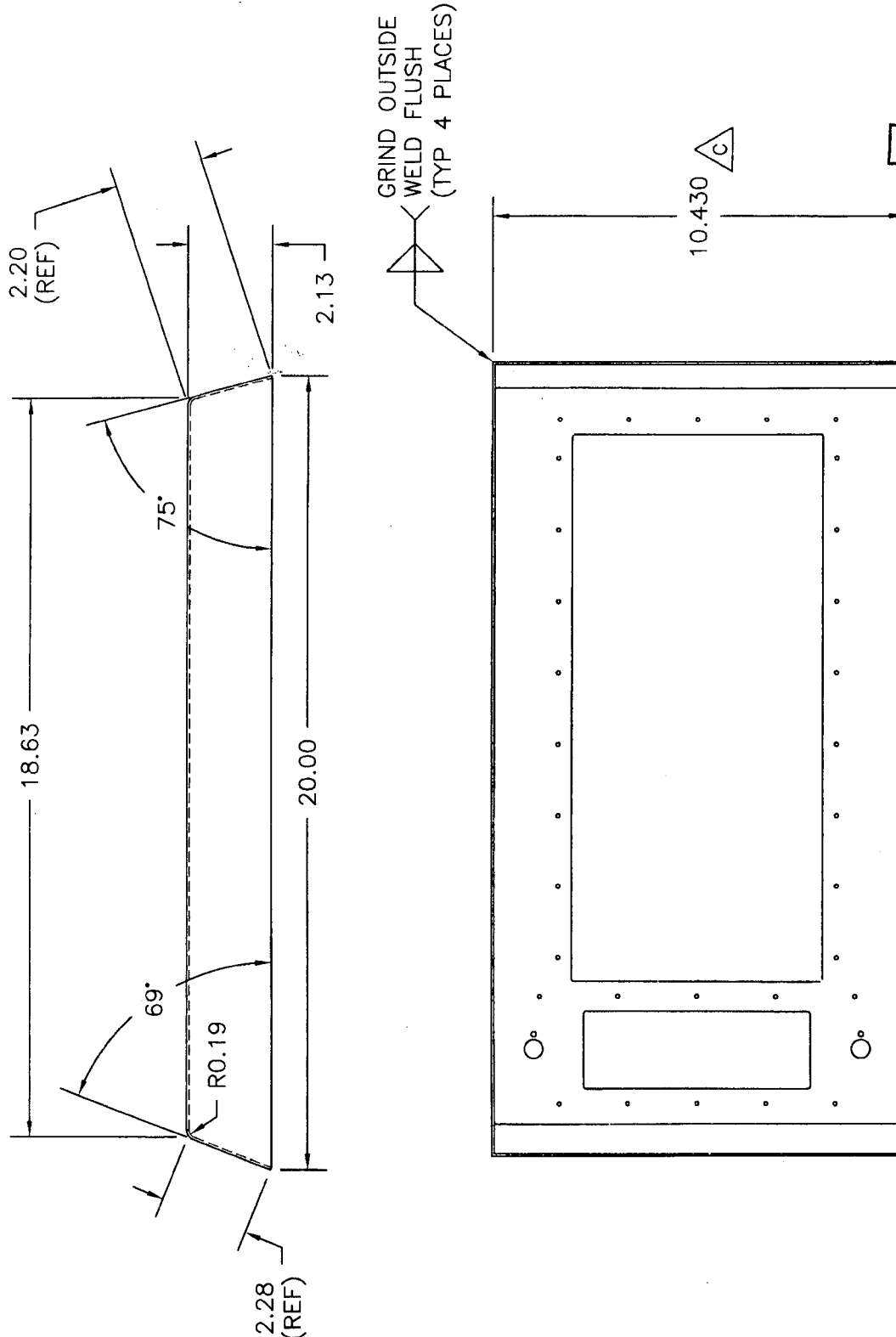
- 1) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
- 2) IDENTIFY WITH DART P/N D3363-041 AND B/N BXXXXX USING FINE POINT PERMANENT INK MARKER
- 3) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Copyright © 2004 by DART AEROSPACE LTD



DESIGN <i>RH</i>	DRAWN BY <i>RH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3363	REV. C SHEET 2 OF 3
DATE 07.01.26	TITLE CONSOLE ASSEMBLY		SCALE 1:4



RELEASED

07.06.04

D3363-1 BEND DETAIL

(MAKE FROM D3363-1F FLAT PATTERN)

D3363-1 CONSOLE

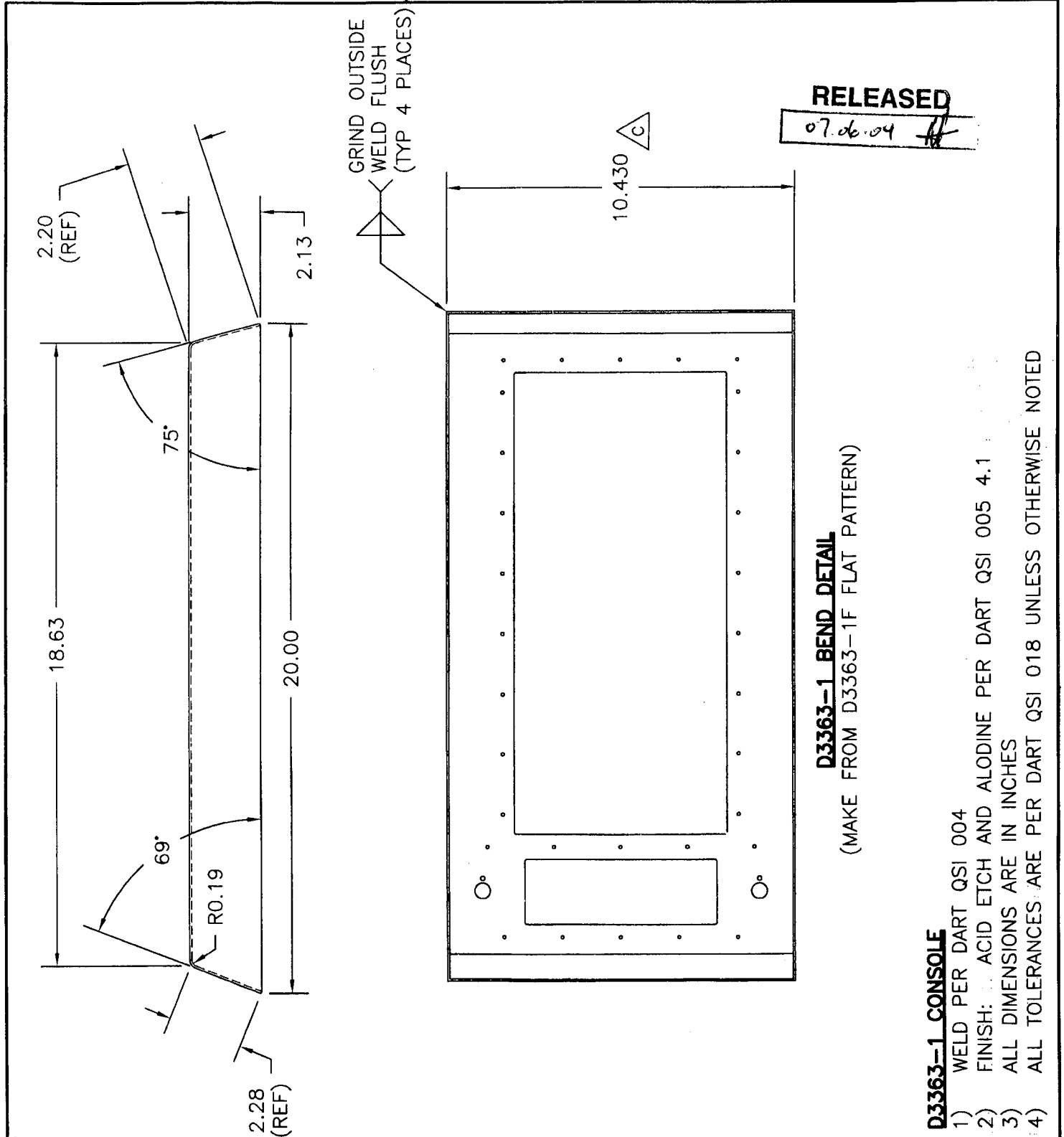
- 1) WELD PER DART QSI 004
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

Copyright © 2004 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



DESIGN <i>RH</i>	DRAWN BY <i>RH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3363	REV. C SHEET 2 OF 3
DATE 07.01.26	TITLE CONSOLE ASSEMBLY		SCALE 1:4



D3363-1 CONSOLE

- 1) WELD PER DART QSI 004
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

Copyright © 2004 by DART AEROSPACE LTD

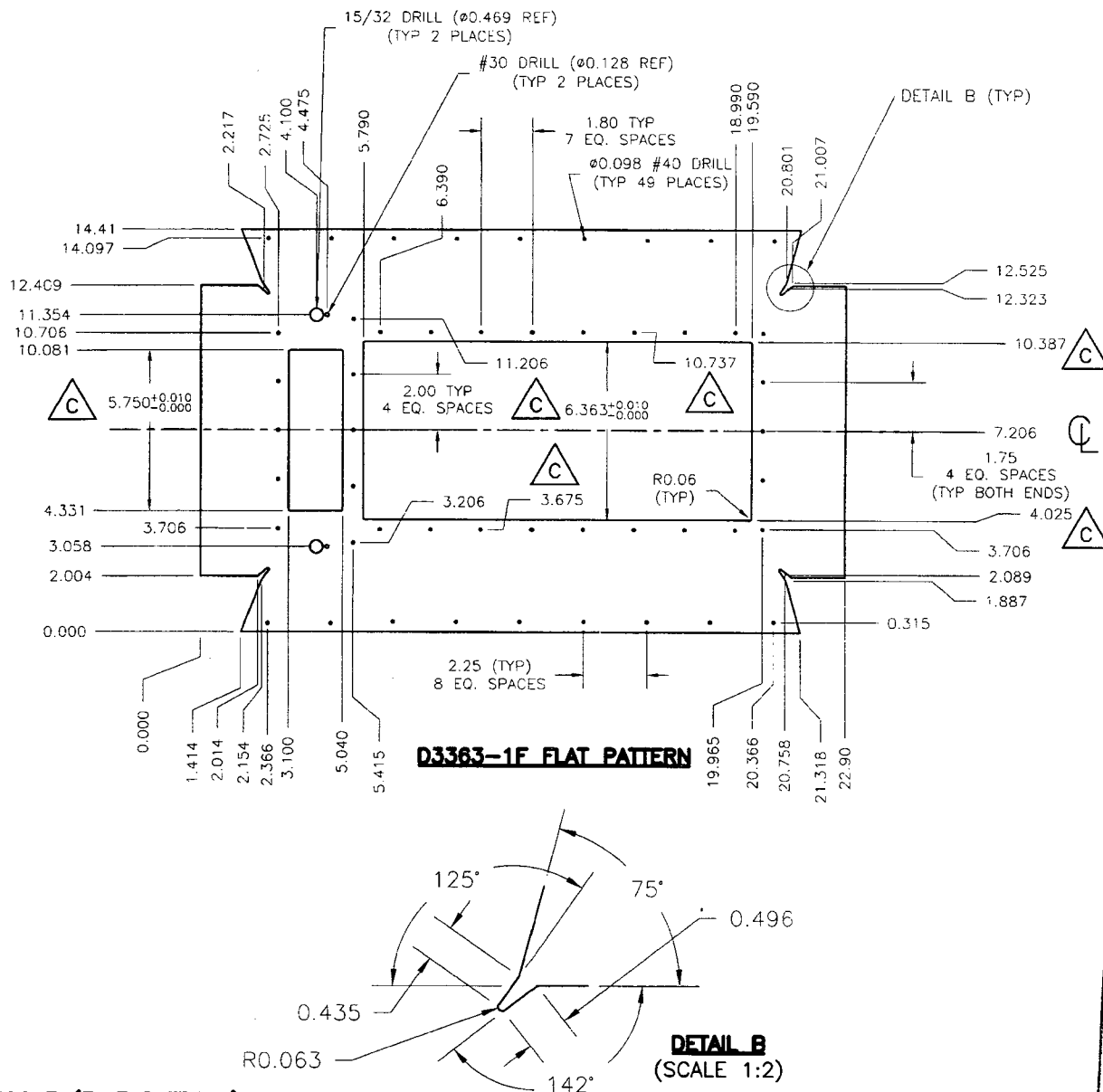
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

DART

DESIGN	24	DRAWN BY	GH	DART AEROSPACE LTD
CHECKED	3	APPROVED		HAWKESBURY, ONTARIO, CANADA
DATE	07.01.26	TITLE	D3363	REV. C
			CONSOLE ASSEMBLY	SHEET 3 OF 3
				SCALE 1:6

RELEASED

07.06.04



D3363-1F FLAT PATTERN

D3363-1F CONSOLE (FLAT PATTERN)

- 1) MATERIAL: 6061-T6/T651 ALUMINUM 0.063 THICK
PER QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF DART SPEC M6061T6S.063)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) PART IS SYMMETRICAL ABOUT CENTERLINE